

Date: Tuesday, 12/5/2006 8:21:00 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LUG  
 Job Number : 29831  
 Estimate Number : 10337  
 P.O. Number : N/A Part Number : D28073  
 This Issue : 12/5/2006 S.O. No. : N/A Drawing Number : D2807 REV C  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : C  
 Previous Run : 28489 Material : N/A  
 Written By : Due Date : 1/5/2007 Qty: 80 Um: Each  
 Checked & Approved By : JF 06/12/05  
 Comment : Est A 05.06.02 New Issue KJJ/JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M303R0750 303 Round Bar .75"



Comment: Qty.: 0.1094 f(s)/Unit Total : 8.7528 f(s)  
 Material: 303 Round Bar Ø0.750"  
 (M303R0.750)

Batch: 4102318

J.F. 06/12/19

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: HARDINGE  
 Turn as per Folio FA529 and Dwg D2807 Dwg Rev: C

2-Deburr

J.F. 06/12/19

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 06/12/19

4.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: Haas #1  
 Machine as per Folio FA528 and Dwg D2807 Dwg Rev: C  
 Folio Rev: AA

2-Deburr

J.F. 07/03/10

(137)

5.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 07/03/10

(137)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: AD Date: 07/03/13  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/5/2006 8:21:00 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 29831

Part Number: D28073

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

57/03/11

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5

57/13/12 (137)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(137)  
57/03/13

Job Completion



57-03-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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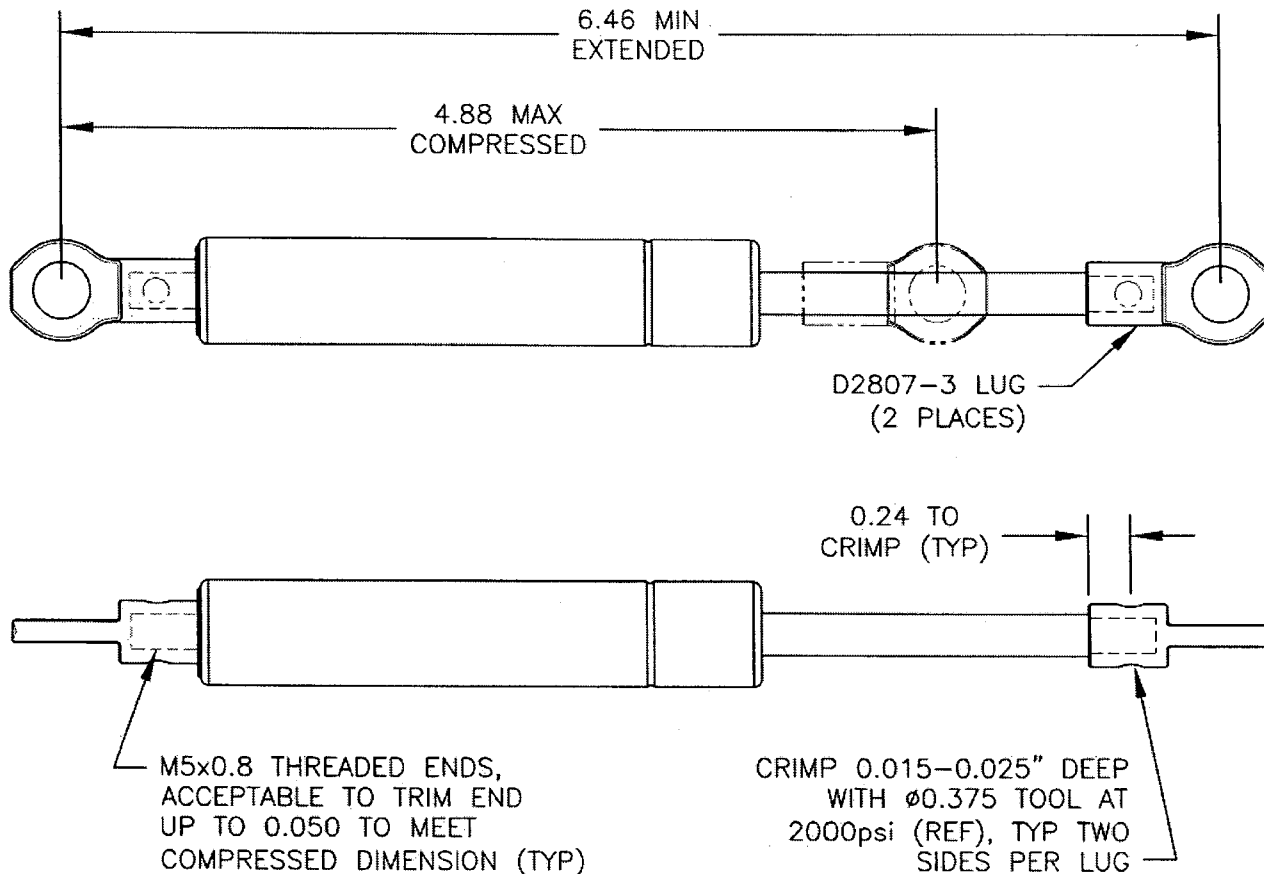
**NOTE:** Date & initial all entries



**DART**

RELEASED  
#05.06.16

DESIGN	DRAWN BY	DART AEROSPACE LTD
CP	CP	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
		D2807
DATE		TITLE
05.05.25		GAS SPRING
A	00.11.03	NEW ISSUE
B	05.03.16	ADD FINISH
C	05.05.25	CHANGE SPRING TO SS, ADD -3 LUG
		SCALE
		1:1
		REV. C
		SHEET 1 OF 2

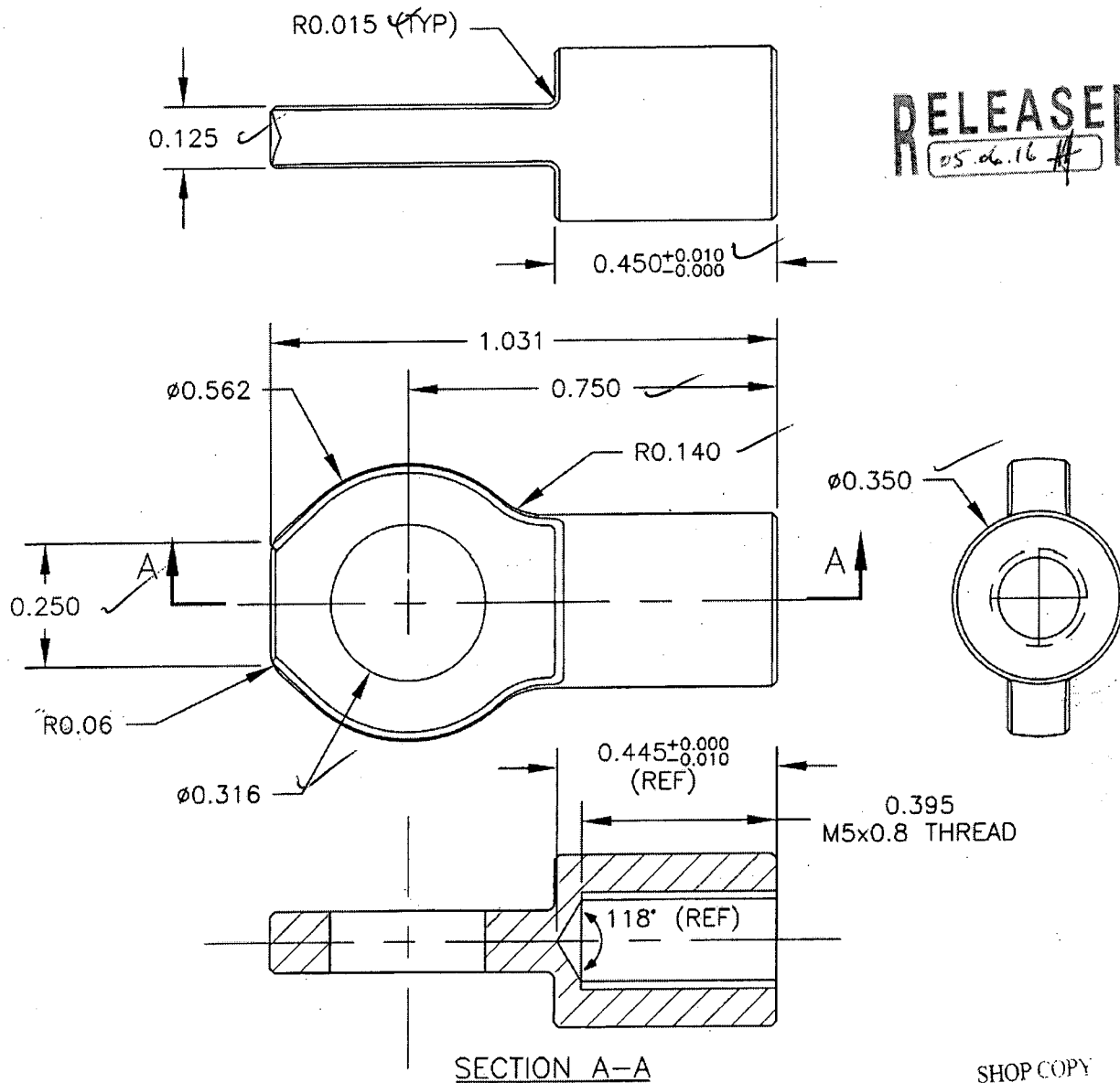


### D2807 GAS SPRING

- SPECIFICATION: SS GAS SPRING  
ACCEPTABLE LOAD RANGE IS 25 lb MIN TO 45 lb MAX  
M5x0.8 THREADS  
SHEET 1 OF 2  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO 29831  
LIER: ArvinMeritor Motion Control Systems, Leicester, UK  
P/N: SXF6S6050080S6L-115N  
(REF: 80mm LONG CYLINDER, 50mm STROKE, 115N LOAD)
- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD	
CP	CP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
#	#	D2807	SHEET 2 OF 2
DATE		TITLE	SCALE
05.05.25		GAS SPRING	3:1

**D2807-3 LUG**

- 1) MATERIAL: AISI 303 ROUND BAR (REF DART SPEC. M303R)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.015
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY  
RETURN TO  
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WITHOUT NOTICE  
WORK ORDER  
NO. 29831

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